

Split B

DART AEROSPACE LTD	Work Order:	2314 B
Description: Cover	Part Number:	D3138-1
Dwg: D3138 Rev. B	Qty:	704
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	05-04-27	10
2	PG	Issue P/O: <u>707986</u> Email or Ship DXF file to vendor Laser Cut D3138-1 flat pattern per Dwg D3138 Possible Supplier: GFI or Industrial Laser Material release note is required	U	05-05-04	10
3	RG	Receive and Inspect for transit damage Enure material release note is attached	CL	05/05/31	10
4	QC6	Inspect dimensions as per Dwg D3138	FF	05/06/07	10
5	GA	Deburr	FF	05/06/10	10
6	GA	Bend as per Dwg D3138	2	05-06-10	10
7	QC5	Inspect work to Step 6	FF	05/06/10	10
8	FP	Chemical Conversion Coat per QSI 005 4.1	FF	05/06/10	10
9	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) per QSI 005 4.3	VM	05/06/13	10
10	QC3	Inspect Powder Coat	CL	05/06/14	4
11	ST	Identify and Stock with part number and batch number using fine point permanent ink marker as per view B-B top surface Dwg D3138	CL	05/06/14	4
12	AC	Cost / part: <u>27.68</u>	AP	05/06/15	4
13	DC	Close W/O <u>42.19</u> Inspect Level 21	HA	05.06.15	4

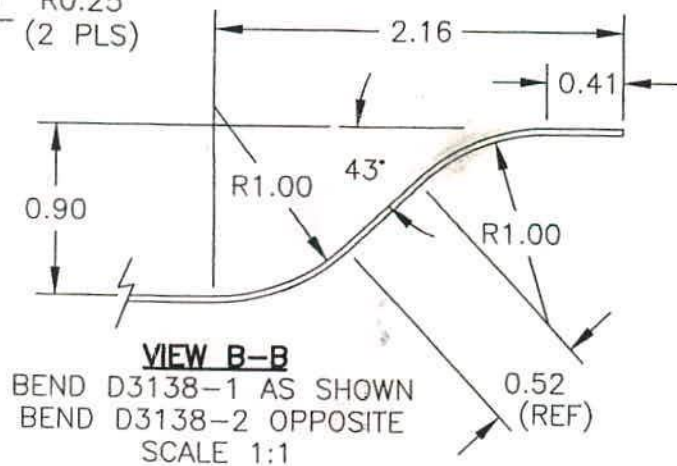
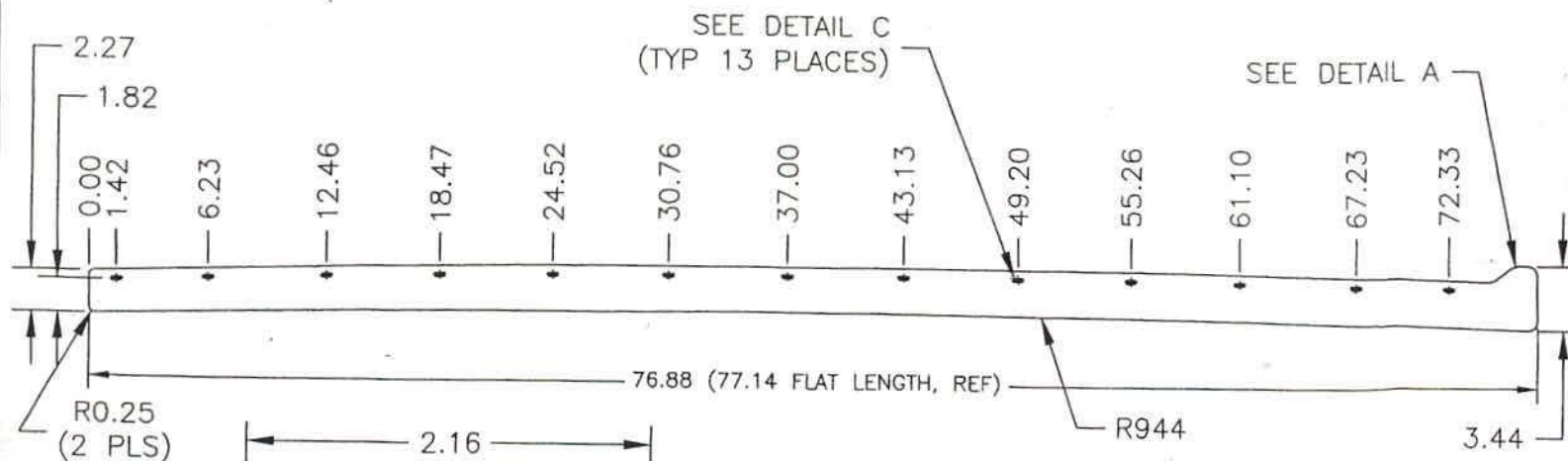
Rev	Date	Change	Revised By	Approved
A	02.05.24	New issue	NG	
B	04.11.29	Made by Laser Cut	KJ/RF	

RELEASED
10/11/30

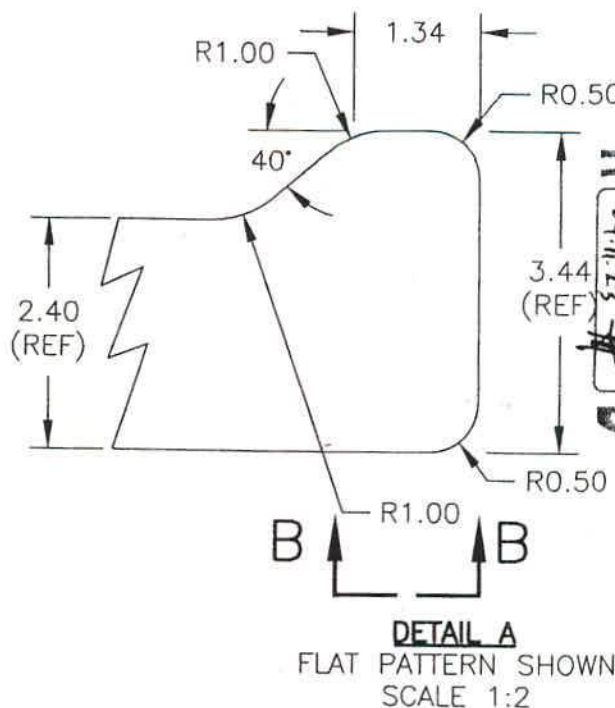
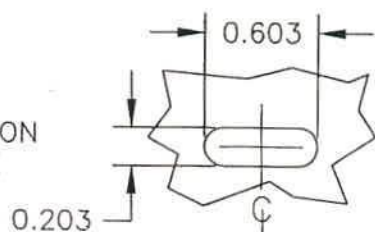


CONTROLLED COPY

DESIGN	DRAWN BY	DART AEROSPACE LTD
PT	PT	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PT	PT	D3138
DATE	TITLE	REV. B
04.07.20	COVER	SHEET 1 OF 1
A	02.04.18	NEW ISSUE
B	04.09.20	RE-DESIGN
REFERENCE ONLY		



DETAIL C
LOCATION DIMENSION
TO CENTERLINE
SCALE 1:1



D3138-1 COVER (SHOWN. REPLACES PREMIER P/N B30-23000-205)

D3138-2 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-206)

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1 OUR JOB NO J0127443 SHIPPING MEMO 0304257

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG. ISSUE
--	10 PCS	2007986	D3138-1		COVER	B

MATERIAL AL 2024-T3 (QQ-A-250/4) SUPPLIED BY SAMUEL SPECIALTY MAT. REL. NO. 0058764 ATT'D

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 27 MAY 2005

G.F.I. Q.C. REP. *Patton H. Stet*



Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ – LETTER OF COMPLIANCE

Date: 10 MAI 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058764
Customer's order #:

de commande SSMQ: 841339
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described: .

[illegible]

Bien à vous,
Yours truly,

Jose Raymond

Commis à l'administration.
Administration Clerk.



LES MÉTAUX SPÉCIALISÉS SAMUEL, 21525 CLARK-GRAHAM, BAIE d'URFÉ, QUÉBEC H9X 3T5
SAMUEL SPECIALITY METALS, 21525 CLARK-GRAHAM, BAIE D'URFÉ, QUÉBEC H9X 3T5

TÉL: 514-457-3399
FAX: 514-457-9393

LET. DE. COM 12/01/04

SHIP TO:

LES METAUX SPECIALISES SAMUEL
(SHIP TO)
21525 CLARK GRAHAM
BAIE D'URFE, PQ, CA H9X3T5

SOLD TO:

SAMUEL SON & CO LTD
2225 FRANCIS HUGHES
LAVAL, PQ, CA H7S1N5

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4011938

CUSTOMER PO NUMBER: N16221		CUSTOMER PART NUMBER:		SHIPPING RUN #/LOAD ID: 100089/2		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1008983	LINE ITEM: 1	SHIP DATE: 9-JUL-2004		ALLOY: 2024	CLAD: BARE	TEMPER: T3	
WEIGHT SHIPPED: 3928 LB	QUANTITY: 173 PCS EST.	B/L NUMBER: 202031		GAUGE: 0.0320 IN	WIDTH: 48.00 IN	LENGTH: 144.000 IN	

Certified Specifications

AMS 4037/RevN

AMS-QQ-A-250/4/RevA

ASTM B 209/Rev04

Test Code: 1504

Test Results

Lot: 226511		Cast	Drop		Ingot							
Tensile:	Temper	Dir / # Tests		Ultimate KSI (MPA)		Yield KSI (MPA)		Elongation %				
	T3	LT / 2 (Min:Max)		67.4 : 67.6 (465 : 466)		45.2 : 45.3 (312 : 312)		17.8 : 18.3				
Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	TOT	OTHER
Actual	0.08	0.22	4.46	0.55	1.32	0.01	0.17	0.01	0.01	0.00		0.06

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772 (MIL-H-6088). ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR